



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4102-1

Job Sheet 194191



Part No: D4102-1

Job Qty: 2 pcs

Part Name: Shim



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Due Date: 5/10/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV B SHEET 1 IPP REV:A NEW ISSUE 10-07-05 JLM VERIFIED BY:DD

Ship Via:

Order 3877

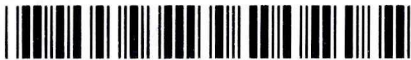
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	2 pcs		5/10/19	0.00	0.03	Bandsaw - 1		B. 19-05-05
110	HAAS 4 Axis - B4B	2 pcs		5/10/19	0.00	1.10	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		B. 19-05-05
120	QC 2	2 pcs		5/10/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		B. 19-05-05
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
							QC 2 - 71		
130	QC 8	2 pcs		5/10/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		B. 19/05/11
							QC 8 - 17		
							QC 8 - 20		



Container No: S178025



Part: D4102-1

Job No: 194191

Serial No/Batch: S178025

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

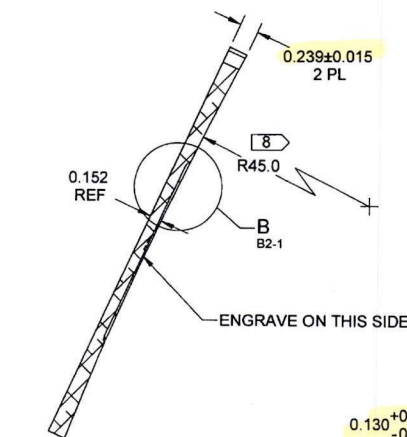
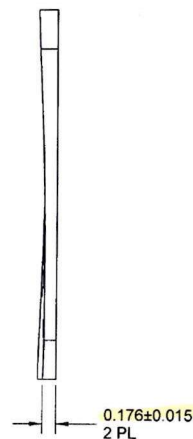
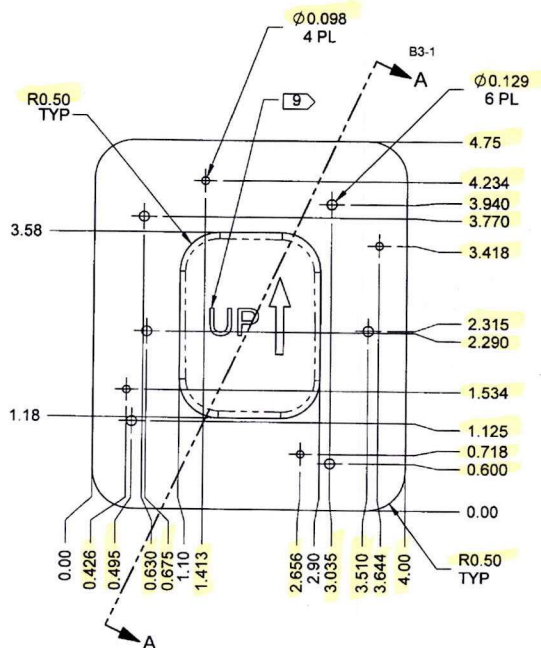
Date: 05/05/19

Plex 4/26/19 12:52 PM Dart.Renwick.Jennife

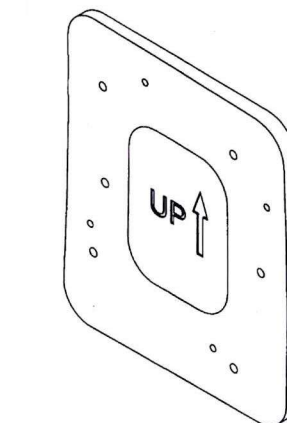
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140	Handfinish - 1-1 Chemical-B4B	2 pcs	5/10/19	0.00 0.09	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
150	QC 7	2 pcs	5/10/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48

D.R. 19/05/13

					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
160	Packaging 3-1 - Stock - B4B	2	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	2	5/10/19	0.00 0.00	QC 21 - SA - 21	
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - (Bandsaw) Cut blanks as per folio 4.950" long Descriptions: 110 - (HAAS CNC Vertical Machine) MILL AS PER DWG AND FOLIO FA945 FOLIO REV: _____ DWG REV: _____ DEBURR 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - QC7-Inspect Chemical Conversion Coat 160 - Identify as per dwg & Stock Location: _____ 170 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M6061T6B0.250X04.000	M2024T3B0.250X4.500	.8400 ft (.42 ea)	100-Bandsaw - 1	5080897		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Bandsaw - 1	M6061T6B0.250X04.000	1	30	0		
Part Specifications						
Specifications could not be found.						



SECTION A-A D6-1



DETAIL B SCALE 2X C3-1

D4102-1 SHIM



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
PER DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4102-1" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.30 lbs
- 8) SURFACE FINISH MINIMUM 250 MICROINCH
- 9) ENGRAVE "UP & ARROW" TO A DEPTH OF MAXIMUM 0.020 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.063

RELEASED
2010-08-23
JNP

B	RE-DESIGN D4102-1/2/3 (ZN B4-1, B4-2, B4-3)	RF	10.08.06
A	NEW ISSUE	RF	10.06.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DATE	10.08.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 194191
Description: SHIM		Part Number: D4102-1
Inspection Dwg: D4102 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.426	+/- .010	0.425	✓		H-6	31006
0.495	+/- .010	0.494	✓		"	"
0.630	+/- .010	0.629	✓		"	"
0.675	+/- .010	0.674	✓		"	"
1.413	+/- .010	1.412	✓		"	"
2.656	+/- .010	2.655	✓		"	"
3.035	+/- .010	3.034	✓		"	"
3.510	+/- .010	3.509	✓		"	"
3.644	+/- .010	3.643	✓		"	"
4.00	+/- .030	3.999	✓		Vern	GA-13
R0.50	+/- .030	R0.500	✓		R-6	ref.
0.600	+/- .010	0.600	✓		H-6	31006
0.718	+/- .010	0.718	✓		"	"
1.125	+/- .010	1.125	✓		"	"
1.534	+/- .010	1.534	✓		"	"
2.290	+/- .010	2.290	✓		"	"
2.315	+/- .010	2.315	✓		"	"
3.418	+/- .010	3.418	✓		"	"
3.770	+/- .010	3.770	✓		"	"
3.940	+/- .010	3.940	✓		"	"
4.234	+/- .010	4.234	✓		"	"
4.75	+/- .030	4.751	✓		Vern	GA-13
φ0.129	+ .005 / - .001	φ0.129	✓		"	"
φ0.098	+ .004 / - .001	φ0.099	✓		"	"
R0.50	+/- .030	R0.500	✓		R-6	ref.
0.176	+/- .015	0.173	✓		Vern	GA-13
0.239	+/- .015	0.238	✓		"	"
R0.13	+/- .030	R0.125	✓		R-6	ref.
0.130	+ .000 / - .015	0.128	✓		Mic	118-120

Measured by: G.E	Checked by: [Signature]	QC Inspector:
Date: 19-05-05	Date: 19/05/10	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	